

Work Order ID 67686

Tuesday, March 29, 2011 11:24:32 AM



Page 1

Item ID: D206-642-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-642	Rev N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

8 11/05/11

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

JB

1

11/04/27

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

B67151

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67686

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Tuesday, March 29, 2011 11:24:32 AM

Item ID: D206-642-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-311 Location: <u>82</u> PPP Rev: _____								
140 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

WLF

11-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 1

Work Order ID: 67686

Parent Item: D206-642-311

Parent Item Name: Skidtube LH



Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC
IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
IPP Rev:L 08-09-29 as per DS19421 DD verified by:EC IPP Rev:M
as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-341 Replacement Skidtube		Manufactured	No			110	Each	3.0000	1	1			

Location	Loc Qty	Loc Code
FG082	3	
36550	1	
44043	1	
44044	1	

67107

D206-648-013 GHW Modification		Manufactured	No			110	Each	4.0000	1	1			
--------------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
FG120	4	
67296	4	

B 67296 JB

D2932-1 Saddle LH Out, 206		Manufactured	No			110	Each	0.0000	1	1			
-----------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D2933-1 Saddle LH In, 206		Manufactured	No			110	Each	2.0000	1	1			
----------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST421	2	
66398	2	

B 67790 JB 11/04/27

B 67791 11/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 67686

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2938-1

Manufactured No

110

Each

5.0000

1

1



Saddle LH Out, 206



~~B66251~~ JB

Location

Loc Qty

Loc Code

ST421

2

66399

2

ST428A

3

66251

3

D2939-1

Manufactured No

110

Each

1.0000

1

1



Saddle LH In, 206



66251
B67674 JB

Location

Loc Qty

Loc Code

ST421

1

66400

1

AN3-41A

Purchased No

110

Each

368.0000

8

8



Bolt



JB 11/04/27

Location

Loc Qty

Loc Code

ST354

369

112431

1

114941

68

115936

100

116191

200

114941

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 67686

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2652

Manufactured No

110 Each

364.0000

16 1 16 ✓



Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

320

65049

32

66124

121

66934

167

66124

MS21042L3

Purchased No

110 Each

2,189.0000

8 8 ✓



Nut

Location

Loc Qty

Loc Code

ST300

2189

116391

589

116540

800

116549

800

116540

AN960JD10

NAS1149D0363J Purchased

No

110 Each

0.0000

8 8 ✓



Washer

AN5-10A

Purchased No

110 Each

152.0000

4 4 ✓



Bolt

Location

Loc Qty

Loc Code

ST337

152

115700

2

116704

50

116924

50

117010

50

117010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 67686

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-11A Purchased No
Bolt

110 Each 61.0000

4 4 ✓

JB SP

Location	Loc Qty	Loc Code
ST337	61	
115422	6	
116419	25	116419
116978	30	

AN960JD516 NAS1149D0563J Purchased No
Washer

110 Each 0.0000

8 8 ✓
m117291

JB SP

AN4-6A Purchased No
Bolt

110 Each 1,079.000

12 12 ✓

JB SP

Location	Loc Qty	Loc Code
ST356	1079	
115936	200	
116191	79	116191
116406	400	
116924	400	

AN960JD416 NAS1149D0463J Purchased No
Washer

110 Each 0.0000

25 25 ✓
m117065

JB SP

MS21042L4 Purchased No
Nut

110 Each 3,324.000

12 12 ✓

JB 11/04/27 SP

Location	Loc Qty	Loc Code
ST300	3324	
116188	1324	116188
116823	2000	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 67686

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110

Each

1.0000



Tow Ring



6F339

11/15/11

Location

Loc Qty

Loc Code

ST420

6

66386

6

ST464

1

64071

1

D3456-1

Manufactured No

110

Each

62.0000



Washer



B68748

JB 5/1

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

55

64282

5

66848

50

D3457-1

Manufactured No

110

Each

24.0000



Washer



JB 11/04/27

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

14

66030

14

66030

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 67686

Parent Item: D206-642-311

Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

737.0000

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

697

116188

397

116549

300

AN4C5A

Purchased

No

110

Each

544.0000

BOLT

Location

Loc Qty

Loc Code

FP-B

117

112243

117

ST345

427

112243

427

AN960C416

NAS1149C0463

Purchased

No

110

Each

0.0000

R

washer

D3413-1

Manufactured

No

110

Each

48.0000

Ring

Location

Loc Qty

Loc Code

ST420

22

62961

8

66387

14

ST473

26

53446

1

65294

10

66945

15

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Tuesday, March 29, 2011 11:24:41 AM

Work Order ID: 67686



Parent Item: D206-642-311



Parent Item Name: Skidtube LH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2712 1

Manufactured No

110 Each

571.0000

10 10 ✓



Set Screw



JB JD

Location

Loc Qty

Loc Code

FG	50	
29962	50	
ST012	252	
66955	252	
ST021	269	
61331	19	
65115	250	

65115

D2934

Manufactured No

110 Each

21.0000

2 2 ✓



Saddle Spacer



JB JD

Location

Loc Qty

Loc Code

FG	6	
31929	6	
ST027	15	
66043	15	

66043

D2935

Manufactured No

110 Each

80.0000

2 2 ✓



Saddle Spacer



JB 11/04/27 JD

Location

Loc Qty

Loc Code

ST027	80	
63558	9	
66564	71	

63558

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Date: 09.09.09

